

3125 58W

Work Order ID 67777

Wednesday, March 30, 2011 10:37:49 AM



Item ID: D3670-4-200

Accept



Setup Start



Revision ID:

Stop



Item Name: SPACER

Start Date: 3/30/2011 Start Qty: 40.00



Cust Item ID:

Required Date: 4/4/2011 Req'd Qty: 40.00



Customer:

Reference:

Approvals:

Process Plan:

M

Date: 11-03-30

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3670	Rev A								
100	Hardinge CNC LATHE SMALL	0.00							
	Hardinge	0.00							
Hardinge CNC Lathe Small	Memo 1-TURN AS PER FOLIO FA711 & DWG D3670 FOLIO REV: DWG REV: 2-DEBURR AS REQUIRED								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
	QC	0.00							
Quality Control	Memo								
120	QC8- Inspect parts - second check	0.00							
	QC	0.00							
Quality Control	Memo								

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Item Name: SPACER

Start Date: 3/30/2011 Start Qty: 40.00



Cust Item ID:

Required Date: 4/4/2011 Req'd Qty: 40.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Packaging

Identify as per dwg & Stock Location

LG

0.00

Memo

0.00

STOCK IN SKIDTUBE CELL

39 0 BEB/04/15

140



QC

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

Quality Control

11/4/18 JF

MIF

11-04-15

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Picklist Print

Wednesday, March 30, 2011 10:37:55 AM

Page 1

Work Order ID: 67777

Parent Item: D3670-4-200

Parent Item Name: SPACER



Start Date: 3/30/2011

Required Date: 4/4/2011

Start Qty: 40.00

Required Qty: 40.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6T0.3125W.05 8		Purchased	No				f	153.4970		14.40720			



ALUM TUBE .3125 x .058w



SA 11/4/7

Location

Loc Qty

Loc Code

MAT013

153.497

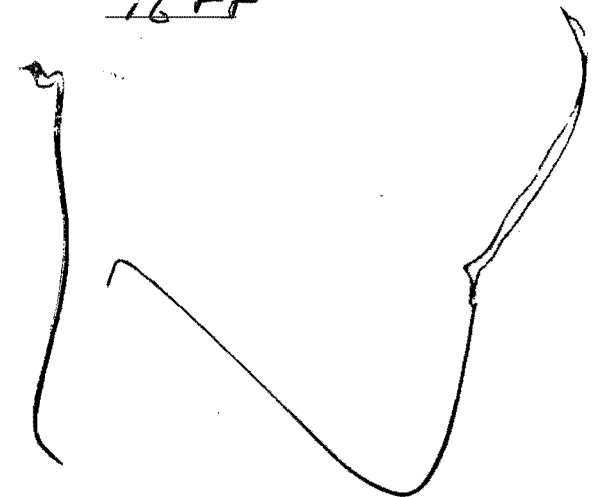
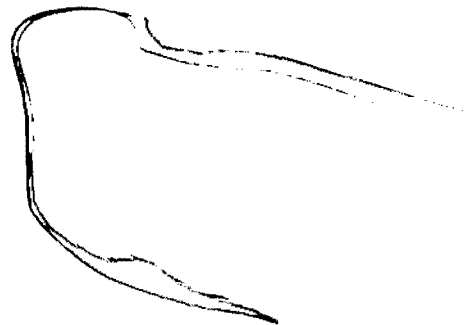
116793

1.667

116939

151.83

16 AA



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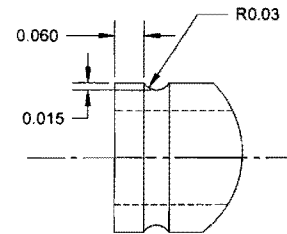
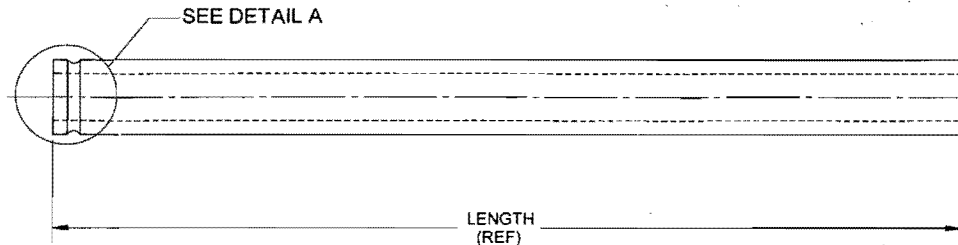
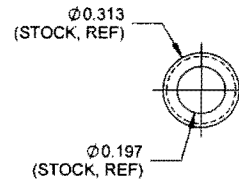
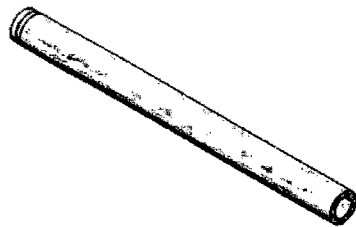
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SPECIFICATION CONTROL DRAWING



DETAIL A
(SCALE 4 : 1)

SPECIFICATION: D3670-XXXX SPACER
LENGTH

WHERE XXXX IS LENGTH IN INCHES
EG: 3.750" LONG SPACER: D3670-3750

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 47777

PH 11-03-30

RELEASED
07.11.06

NOTES:

- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING 0.313" OD X 0.058" WALL
PER WW-T-700/6 OR AMS 4080 OR AMS 4082
OR QQ-A-200/8 OR QQ-A-225/8
(REF. DART SPEC. M6061T6T0.313W.058)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A

A	NEW ISSUE	DC	07.10.19
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>DC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>DC</i>		
CHECKED	<i>h</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>h</i>	D3670	SHEET 1 OF 1
APPROVED	<i>h</i>	TITLE	SCALE
DE APPR.	<i>h</i>	SPACER	2:1
DATE	07.10.19	COPYRIGHT © 2007 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIES OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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